

Date: Friday, 11/18/2005 5:40:15 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 24891	
Estimate Number : 10033	
P.O. Number : N/A	Part Number : D6101003
This Issue : 11/18/2005 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/20/2005 Qty: 100 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 154

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000" h 05.11.23

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
7075-T7351 2X6X6.25

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached CL 05/12/22 100

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101 EP 05/12/22 100

WORK ORDER CHANGES								
W/O	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/17
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:40:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 24891

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C' 06/01/16 100

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.5 06/01/17

(100)

100

06/01/17

(100)

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	: 0024891	Department Code:	
Project Name	: D6101-003	Burden Flags	: NNNNNNNN
Project For	: WK602	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-003	Invoice Number	:
Description	: 7075-T7351 2X6.25X7.875	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-18-05		
Est Finish Date	: 01-15-06	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



40 Skyline Drive, Plainview, NY 11803 Tel: 516.822.8300 Fax: 516.822.8332

Customer PO #

00000154

Order Date

11/23/05

SP

JP

Sales Order Number

5465

Invoice Date

12/21/2005

Invoice Number

27657

Ship To:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Pkg.

4 SKIDS

Weight

4590 LBS

Terms

50% CIA/BAL N...

Ship Date

12/21/2005

Shipped Via

THROWBRIDGE ...

Freight

COLLECT

FOB

ORIGIN

Test Reports

Y

Item No.	Orig. Qty	Unit	Description	Bal. on Order	Qty This Shipment
1	100	EA	7075-T7351 QQ-A-250/12 6.00" X 6.25" X 2.00" THK (GRAIN ALONG 6" DIM)		100
2	100	EA	7075-T7351 QQ-A-250/12 7.875" X 6.25" X 2.00" THK. ✓ (GRAIN ALONG 7.875 DIM)		100
3	100	EA	7075-T7351 QQ-A-250/12 5.00" X 6.25" X 2.50" THK (GRAIN ALONG 5" DIM)		100
4	100	EA	7075-T7351 QQ-A-250/12 7.75" X 8.25" X 2.50" THK (GRAIN ALONG 7.75" DIM)		100
			CUT TOLERANCE ON ALL IS +.063/-00		

PACKING LIST

CERTIFICATE OF COMPLIANCE

We certify that the materials described above conform to the specifications stated.

Cathie Vail

Quality Control Manager

PECHINEY ROLLED PRODUCTS

DIVERSIFIED INDUSTRIAL PRODUCTS
40 SKYLINE DRIVE
PLAINVIEW, NY 11803

CERTIFIED TEST REPORT
RAVENSWOOD, WV 26164 USA

SAME

SERIAL#: 20051027877903 1

CUSTOMER PURCHASE ORDER NO. & ITEM 4591				PECHINEY ORDER NO. 235-30435		CERTIFICATION "Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." PECHINEY ROLLED PRODUCTS P.O. BOX 68 RAVENSWOOD, WV 26164 USA <i>LaDonna B Smith</i> LADONNA B SMITH - LABORATORY MANAGER	
ALLOY 7075	CLAD. 00	TEMPER T651	GUAGE 2.53000	WIDTH 48.500	LENGTH 28.000		
ITEM ORDERED MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL							
CUSTOMER SPECIFICATION AMS-QQ-A-250/12							
PART NUMBER 090947-3		B/L NUMBER 877900		DATE SHIPPED 10/28/05			
WEIGHT SHIPPED 6,640		NO. OF PIECES 4		GOVT. CONTRACT NO.			

LOT NUMBER	TEST DIRECTION	NO OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN	MAX	MIN	MAX	MIN.	MAX	MIN	MAX									
432851	LT	2	***** T651 79.6	80.0	69.5	70.2	***** 12.5	12.5											

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS																			

ALSO CONFORMS TO AMS 4045H, ASTM B209-04																			
DIVERSIFIED INDUSTRIAL PRODUCTS CORP. CERTIFY THIS A TRUE COPY OF THE MILL TEST REPORT USED TO FILL YOUR ORDER. Company <u>DAVT. Aerospace LTD.</u> PO# <u>00000 154</u> Our Inv. # <u>271057</u> Qty. <u>100 EA</u> Part # _____ QC Dept. <u>Cathy Vail</u> Cathy Vail ITEM # 3 - <u>STANDARD MATERIAL</u>																			
C H E M I C A L C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX	MIN.	MAX.	MIN	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX	MIN.	MAX	MIN	MAX	EACH MAX	TOTAL MAX
	SEE ACTUAL CHEMICAL COMPOSITION																		
ALUMINUM REMAINDER																			

Calvin Hall

347 30 Y400 EURT A SHT VOTR30
 3500 STOUNGON 1A1T3U0M 031013Z
 130900

PECHINEY ROLLED PRODUCTS

DIVERSIFIED INDUSTRIAL PRODUCTS
40 SKYLINE DRIVE
PLAINVIEW, NY 11803

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26184 USA

SAME

SERIAL#: 20051027877903 2

CUSTOMER PURCHASE ORDER NO. & ITEM 4591				PECHINEY ORDER NO. 235-304355		CERTIFICATION *Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination. PECHINEY ROLLED PRODUCTS P.O. BOX 68 RAVENSWOOD, WV 26184 USA <i>Labonna B Smith</i> LABONNA B SMITH - LABORATORY MANAGER	
ALLOY 7075	CLAD. 00	TEMPER T651	GUAGE 2.53000	WIDTH 48.500	LENGTH 28.000		
ITEM ORDERED MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL							
CUSTOMER SPECIFICATION AMS-QQ-A-250/12							
PART NUMBER 090947-3		BAL NUMBER 877900		DATE SHIPPED 10/28/05			
WEIGHT SHIPPED 6,640		NO OF PIECES 4		GOVT. CONTRACT NO.			

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I		YIELD STRENGTH K.S.I		ELONGATION %		COND % IACS											
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.										
432851	ACTUAL CHEMICAL COMPOSITION																			
	SI=0.08 FE=0.16 CU= 1.5 MN=0.03 MG= 2.6 CR=0.21 ZN= 5.6 TI=0.03																			
	OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
	THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE.																			
	THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
	CHEMISTRY BY OES: ARKSPARK																			
	CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
	WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
	WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
	"END OF CERTIFICATION"																			
C H E M C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS		
		MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	EACH	TOTAL	
		MAX																		
	SEE ACTUAL CHEMICAL COMPOSITION																			

Burton Industries, Inc.

243 Wyandanch Avenue North Babylon, NY 11704 (631) 643-6660 FAX (631) 643-6665

Serving the Heat Treating Industry since 1971

Certificate of Compliance

Diversified Industrial Prod. Corp.

40 Skyline Drive

Plainview, NY 11803

(516) 822 - 8300 FAX (516) 822 - 8332

Ref. No: 129817

Issued: 12/20/2005

Material: 7075-T651		Cond. Req'd. T7351		Spec.			
Quantity		Part Number			Purchase Order		
100		6.00 X 6.25 X 2.00" THK			22475		
100		7.875 X 6.25 X 2.00" THK					
100		5.00 X 6.25 X 2.50" THK					
100		7.75 X 8.25 X 2.50" THK					
Process Performed		Date	Temp (F)	Time	Atmosphere	Furnace	Hardness
ARTIFICIAL AGE		12/17/2005	325	26 HRS	AIR	260	
HRB							80-83
Condition T7351		Tested	40	Passed 40		Reject 0	
Conductivity 39.5-41.1 % IACS		Tested	400	Passed 400		Reject 0	

We hereby certify that the articles stipulated above have been processed in conformance with all applicable specifications, drawings, and/or written instructions. Test and/or Inspection Reports indicating conformance are on file for examination

Nancy Maese



Nancy Maese

Q.A. Administrator
Burton Industries, Inc.



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<http://www.heatreat.com>
AS 9100 Compliant



V050405R2A 129806